

Work Order ID 55426

January 18, 2010 10:47:12 AM



Page 1

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 1/18/10 Start Qty: 2.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Ph 10-01-18

2

Ø

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Ph 10-01-18

2

Ø

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 8106113

②

Quality Control

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Item ID: D3572-041

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Revision ID:

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Setup Start

Stop

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Date:

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QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: _____
Large Fab

0.00

Memo

0.00

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572
2- grind weld flush at the end of tube only

10.01.18

2

φ

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 8/10/19

④

φ

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

PD 10.01.19 ②

Work Order ID 55426

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Start Date: 1/18/10 Start Qty: 2.00



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Required Date: 1/20/10 Req'd Qty: 2.00

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Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish 10-01-19

(X2) ✓

HandFinishing

Memo

0.00

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588 => Hf 10-01-19

(X2) ✓

Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:30pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 4:00pm

200

QC3- Inspect Part Finish

0.00

BK 10-01-19

(2) ✓

QC

Memo

0.00

Quality Control

Work Order ID 55426

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Item ID: D3572-041

Accept

Revision ID:

Item Name: Guide Assembly

Start Date: 1/18/10 Start Qty: 2.00

Required Date: 1/20/10 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:



10-1-20 (2x) SP

10/01/20
MF 10-1-20

Picklist Print

January 18, 2010 10:47:11 AM

Page 1

Work Order ID: 55426

Parent Item: D3572-041

Parent Item Name: Guide Assembly

Comments: IPP Rev:A New Issue 07-02-07 JLM
 IPP rev B revB dwg EC
 IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM
 IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Start Date: 1/18/10

Start Qty: 2.00

Required Date: 1/20/10

Required Qty: 2.00

D3572-3 Manufactured No 130 Each 30.0000 8.0000



Guide

10.01.18

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST244 *54118 = 3* 30

55136 30

3
5

D3572-5 Manufactured No 130 Each 31.0000 2.0000



Bracket

10.01.18

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 31

54119 31

2

M6061T6T1.000W.188 Purchased No 110 f 79.5198 4.9263



6061T6 RD TUBE 1.00 X .188W

10.01.18

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT 79.5197542

109041 1.03

112529 20.5647542

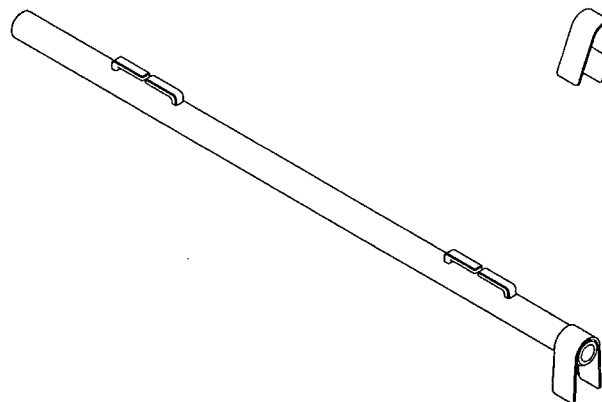
113511 56.325

18101 1.6

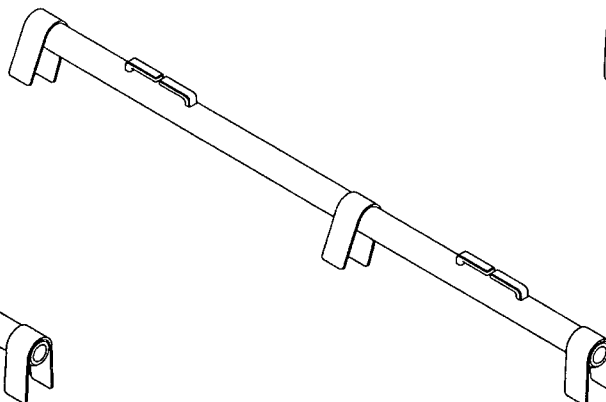
2

ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

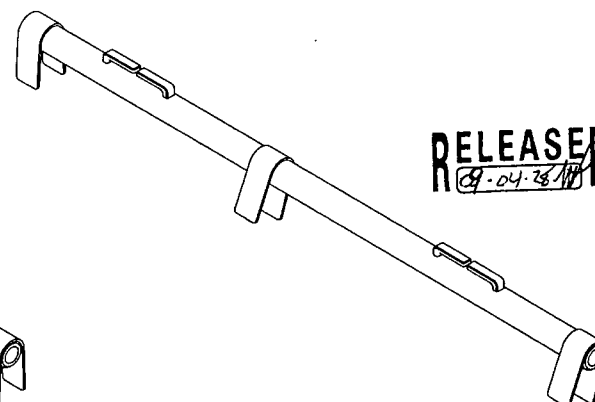
WLO 55426



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



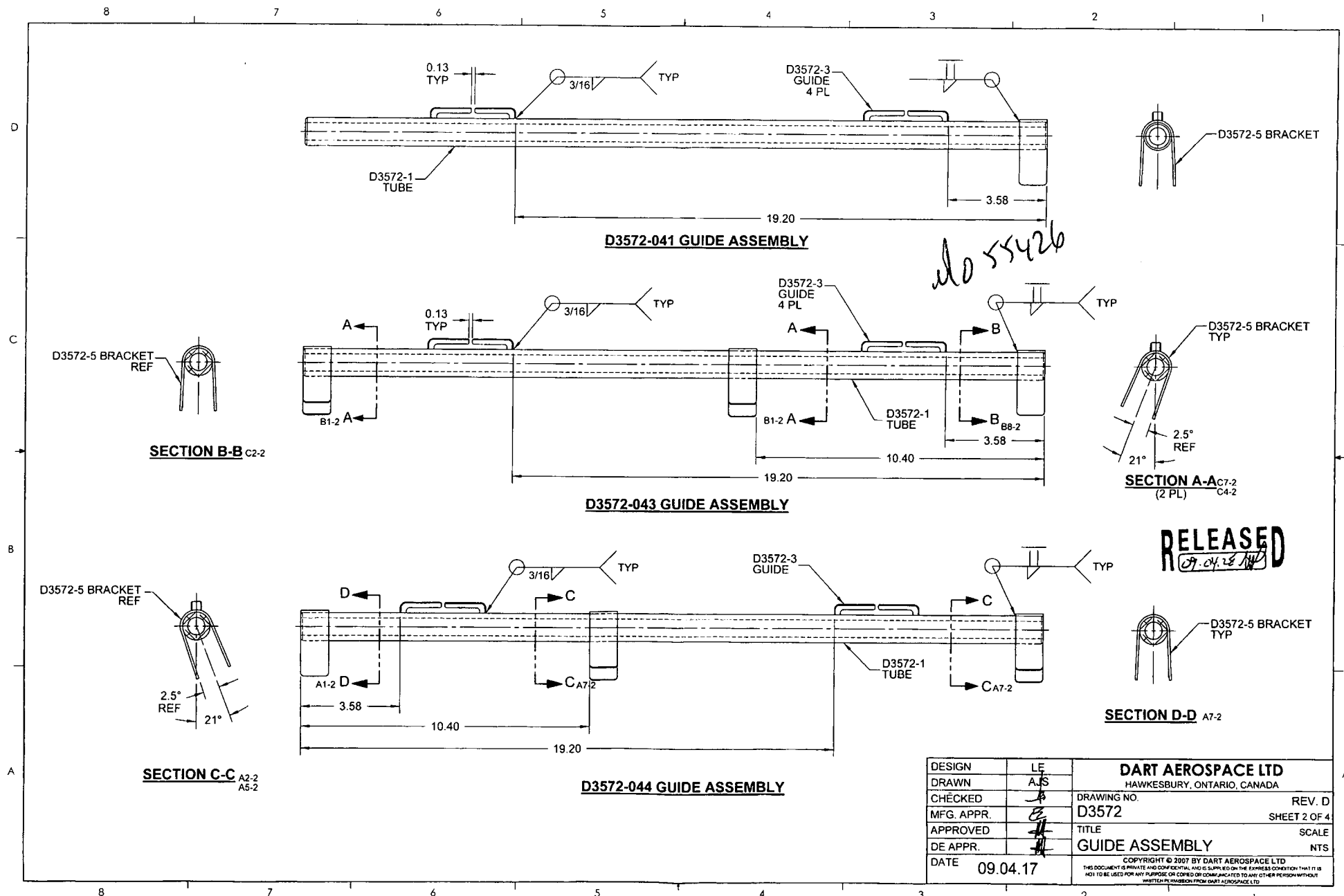
D3572-044 GUIDE ASSEMBLY (UH-1)

RELEASED
09-04-17

NOTES:

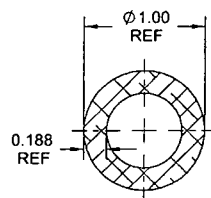
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1 SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. D
MFG. APPR.	LE	D3572	SHEET 1 OF 4
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	GUIDE ASSEMBLY	NTS
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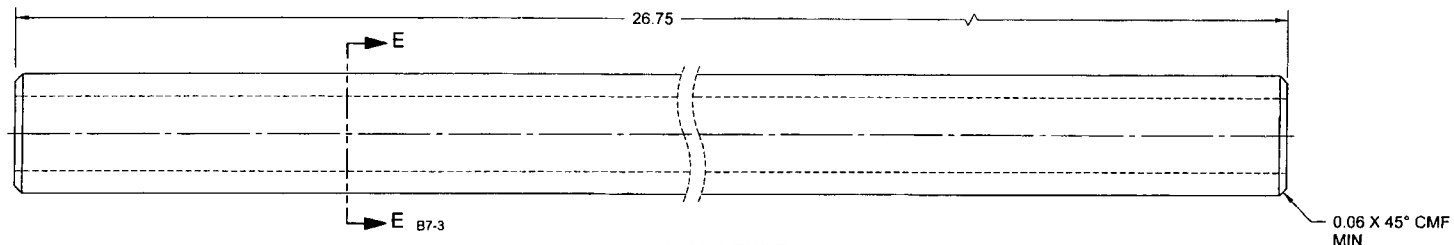


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MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 2 OF 4
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ULO 55426



SECTION E-E C5-3



D3572-1 TUBE

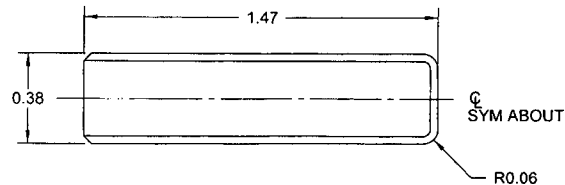
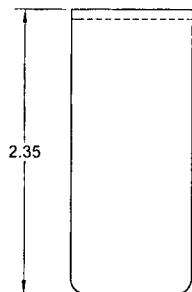
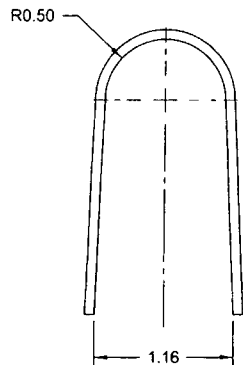
RELEASED
07/04/14

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

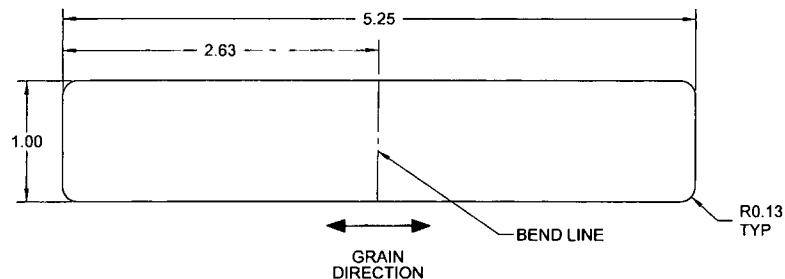
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MFG. APPR.	JS	D3572	SHEET 3 OF 4
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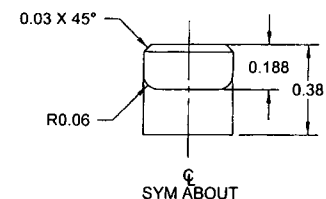
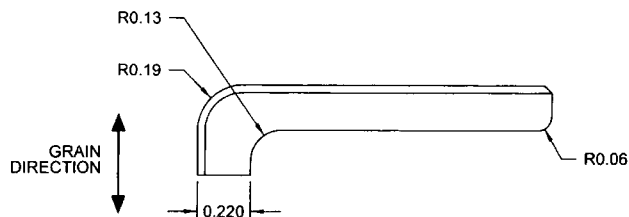


W/5426

D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-5F FLAT PATTERN



D3572-3 GUIDE

RELEASED
9/10/13

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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